

Work Order ID 140265

December 18, 2015 2:48:53 PM

140265

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SA Date: 20151218

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-041	G

100

Document Control

0.00

68-6
9
SV

ML5 16-01-27

100

DC

DOCUMENT CONTROL

0.00

Memo

record fwd angle: 90.0°

Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DD 15-12-21

DAS
28
9-89

JAN 28 2016

B140265 L+1

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Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 12/18/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.02							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

15-12-21

BE 15-12-22

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N900040100

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NS1

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Start Date: 12/18/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampA/R Aluminum Rod batch: m132917

9-Grind welds flush as per Dwg D2750

7 BE 15-12-22

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

① 15-12-22

DAS

9

9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

① 15-12-22

DAS

9

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Start Date: 12/18/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00				1	0	15-12-22	
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00				1	0	15-12-22	
150									
QC	Memo	0.00							
Quality Control									

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 12/18/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

Skidtubes

Memo

0.02

1-Open up holes using hole saw of Detail C and ground handling to 0.625"
(total of 8 holes per side)
as per dwg D2750.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole using un-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 133427exp. date: 16-2-12

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M132917

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

15-12-22
[Signature]

7 8E16-12-23

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Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop *NS2*

Start Date: 12/18/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

10-Grind welds flush as per Dwg D2750 16-1-4 J/L

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

12-Deburr holes, ensure tube is free of all scratches before sending to paint.

170

170

OC

Quality Control

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

Memo	0.00
-------------	------

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38
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JAN 06 2016

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O	0.00
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Memo	0.00
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VERIFY C'BOARD IS GOOD

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 Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.01							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.01							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>132919</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>133885</u>								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

12/11/15 d 16/01/15 16-1-26
 12/11/15 d 16/01/15 16-1-26
 12/11/15 d 16/01/15 16-1-26

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	Memo							
Hand Finishing	1- Install inserts as per Dwg D2750	0.02							
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>1113342 I</u>								
	EXP DATE: <u>16107</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11132145</u> <u>RTU 598</u> <u>11133346</u> <u>1605</u>								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>11122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	Memo							
Quality Control									

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Required Date: 1/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011 Location : FG072								

DAS 6 9-89
DAS 27 9-89
JAN 27 2016
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DAS 27 9-89
JAN 28 2016

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Work Order ID: 140265

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	71.0000	8	8			
D3492-1									**			16/01/27	
Plug													
				<u>Location</u>				<u>Loc Qty</u>					
				FP001				71					
				138411				5					
				139053				6					
				139632				60					
D3492-3		Manufactured	No			230	Each	136.0000	8	8			
D3492-3									**			16/01/27	
Plug													
				<u>Location</u>				<u>Loc Qty</u>					
				FP001				136					
				133470				3					
				138358				45					
				139006				8					
				139597				80					

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

235.0000

8

8

NAS1611-010

O-RING

all 16/01/27

Location

Loc Qty

Loc Code

FP001

235

m130770

175

m131618

60

28

NAS1149D0863J

Purchased

No

250

Each

556.0000

2

2

NAS1149D0863.J

Washer

JAN 27 2016

Location

Loc Qty

Loc Code

FP001

47

125484

47

ST260a

415

125268

315

125635

100

ST269

94

125268

94

2

D2744

Manufactured

No

110

Each

1.0000

1

1

D2744

Cap

BE 15-12-22

Location

Loc Qty

Loc Code

LG001

1

136178

1

D2600-3-BENT-LH

Manufactured

No

110

Each

5.0000

1

D2600-3-BENT-I H

Extrusion Bent LH

15-12-21

Location

Loc Qty

Loc Code

LG002

5

138202

5

1

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D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No

160 Each 107.0000 8 8

D2743

Crossbolt Spacer

**

BB 15-12-23

Location

Loc Qty

Loc Code

LG

34

138392

34

LG001

73

137271

8

139032

65

D2739 Manufactured No

160 Each 3.0000 1 1

D2739

350 I Beam

**

15-12-22

Location

Loc Qty

Loc Code

LG002

3

139095

3

D3490-3 Manufactured No

160 Each 42.0000 4 4

D3490-3

Cross Bolt Spacer

**

BB 15-12-23

Location

Loc Qty

Loc Code

LG001

42

137807

6

139099

16

139710

20

D3490-1 Manufactured No

160 Each 22.0000 4 4

D3490-1

Cross Bolt Spacer

**

BB 15-12-23

Location

Loc Qty

Loc Code

LG

14

133205

14

LG001

8

134019

8

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Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225 Purchased

No

Each

730.0000

38

AI S4-1032-225

Rivnut

**

all 16/01/27

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

610

M133772

610

x38

D3793-3

Manufactured

No

230

Each

23.0000

1

1

D3793-3

Wearplate Aft

**

all 16/6/27

Location

Loc Qty

Loc Code

FP002

23

130534

1

139733

22

x1

AN8C35A

Purchased

No

230

Each

70.0000

1

1

AN8C35A

Bolt

**

all 16/6/27

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

35

m131947

1

m132381

15

m132522

15

m132674

4

over005

30

m133332

15

m133336

15

x1

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

517.0000

4

4

AN6C44A

Bolt

**

gl 16/01/27

Location

Loc Qty

Loc Code

FP001

91

131649

54

m131367

1

m132381

36

X 4

over009

361

m130863

13

m131151

50

m132522

52

m132556

246

ST332

11

m130863

11

ST333

54

m130863

4

m131946

50

MS21083C8

Purchased

No

230

Each

43.0000

1

1

MS21083C8

Nut

**

gl 16/01/27

Location

Loc Qty

Loc Code

ST297

43

m132067

2

m133016

2

m133577

25

m133694

14

✓

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each

24.0000 1 1

D3536-25

Gasket Center

all 12/18/2015

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

18

105965

1

130823

1

132316

1

139433

1

139735

14

X1

D3631-1

Manufactured No

230 Each

90.0000 8 8

D3631-1

Washer

all 12/18/2015

Location

Loc Qty

Loc Code

FP001

90

135951

3

139226

87

41

D3791-1

Manufactured No

230 Each

24.0000 1 1

D3791-1

Wearpad

all 12/18/2015

Location

Loc Qty

Loc Code

FP002

24

128234

1

139736

23

X1

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,056.000

38

38

NAS1149C0332R

WASHER

all 16/01/27

Location

Loc Qty

Loc Code

FP001

1605

m132262

4

m132930

1004

m133284

597

GA

343

X38

m133284

343

ST266

1108

m133284

1108

D2745

Manufactured

No

230

Each

85.0000

8

8

D2745

Bushing

all 16/01/27

Location

Loc Qty

Loc Code

FP001

85

129584

7

136214

2

137731

1

138363

75

X2

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,207.000

34

34

AN3C5A

Bolt

all 16/01/27

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

478

M133234

54

M133769

424

OVER002

600

M133686

600

ST338a

124

M125388

35

m127290

3

M131803

42

M132640

44

X34

D3537-1

Manufactured

No

230

Each

100.0000

3

3

D3537-1

Wearpad

all 16/01/27

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

82

107384

5

125911

1

128225

1

136314

7

136712

21

136713

47

Y3

Picklist Print

December 18, 2015 2:48:59 PM

Page 10

Work Order ID: 140265

140265

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

72.0000

1

1

NAS1149C0832R

Washer

**

all 16/6/27

Location

Loc Qty

Loc Code

FP001

10

m125807

10

ST271

62

m125807

62

x1

AN3C6A

Purchased

No

230

Each

153.0000

4

4

AN3C6A

Bolt

**

all 16/6/27

Location

Loc Qty

Loc Code

CA

31

m128704

31

FG

10

122416

10

FP001

9

m133363

9

ST338a

36

m128769

30

m133077

6

ST349

67

m132767

4

m133694

63

x4

NAS1611-013

Purchased

No

230

Each

262.0000

8

8

NAS1611-013

O-Ring

**

all 16/6/27

Location

Loc Qty

Loc Code

FP001

262

m130758

62

m133812

200

x8

December 18, 2015 2:49:00 PM

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Page 10

Picklist Print

December 18, 2015 2:49:00 PM

Page 11

Work Order ID: 140265

140265

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

3.0000

1

1

D3535-25

Wearplate Center

all 12/18/15

Location

Loc Qty

Loc Code

FG

3

B139987

XL

128224

1

95077

2

D3794-1

Manufactured No

230

Each

26.0000

1

1

D3794-1

Gasket Fwd

all 12/18/15

Location

Loc Qty

Loc Code

FP001

26

130509

2

139039

24

XL

MS21043-6

Purchased No

230

Each

61.0000

4

4

MS21043-6

NUT

all 12/18/15

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

41

131618

2

m130325

2

m133483

4

m133733

33

XL

Picklist Print

December 18, 2015 2:49:00 PM

Page 12

Work Order ID: 140265

140265

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

40.0000

2 2

D3493-1

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	10	
97201	10	
ST039	30	
137724	7	2
139595	23	

DAS
6
9-89

DAS
27
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

MS21083C8

Purchased No

250 Each

43.0000

2 2

MS21083C8

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST297	43	
m132067	2	
m133016	2	
m133577	25	2
m133694	14	

DAS
6
9-89

DAS
27
9-89

JAN 27 2016

Picklist Print

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Page 13

Work Order ID: 140265

140265

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

44.0000

2

2

AN8C21A

Bolt

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

ST332

40

m131100

1

m132169

2

m132381

1

m132522

4

m132674

4

m133332

28

NAS1515H3L

Purchased

No

230

Each

179.0000

4

4

***NAS1515H3L ***

Washer

all 16/01/22

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

84

m127831

32

m130726

52

xy

Picklist Print

December 18, 2015 2:49:00 PM

Page 14

Work Order ID: 140265

140265

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

38.0000 1 1

DAS
6
9-89

DAS
27
9-89

D2741

Replacement Blade

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	10	
131616	10	
ST538	28	
132981	16	
135909	12	

D3532-1

Manufactured No

250 Each

6.0000 2 2

D3532-1

Spacer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST041	6	
139065	6	

DAS
6
9-89

DAS
27
9-89

JAN 27 2016

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

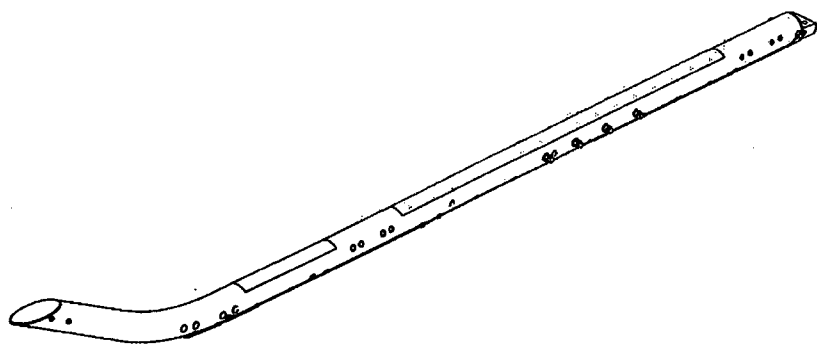
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

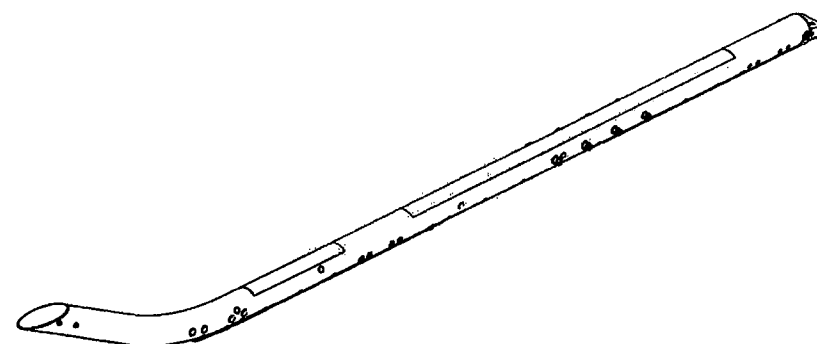
RELEASED
2013-08-13

20151218
SW 140265

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



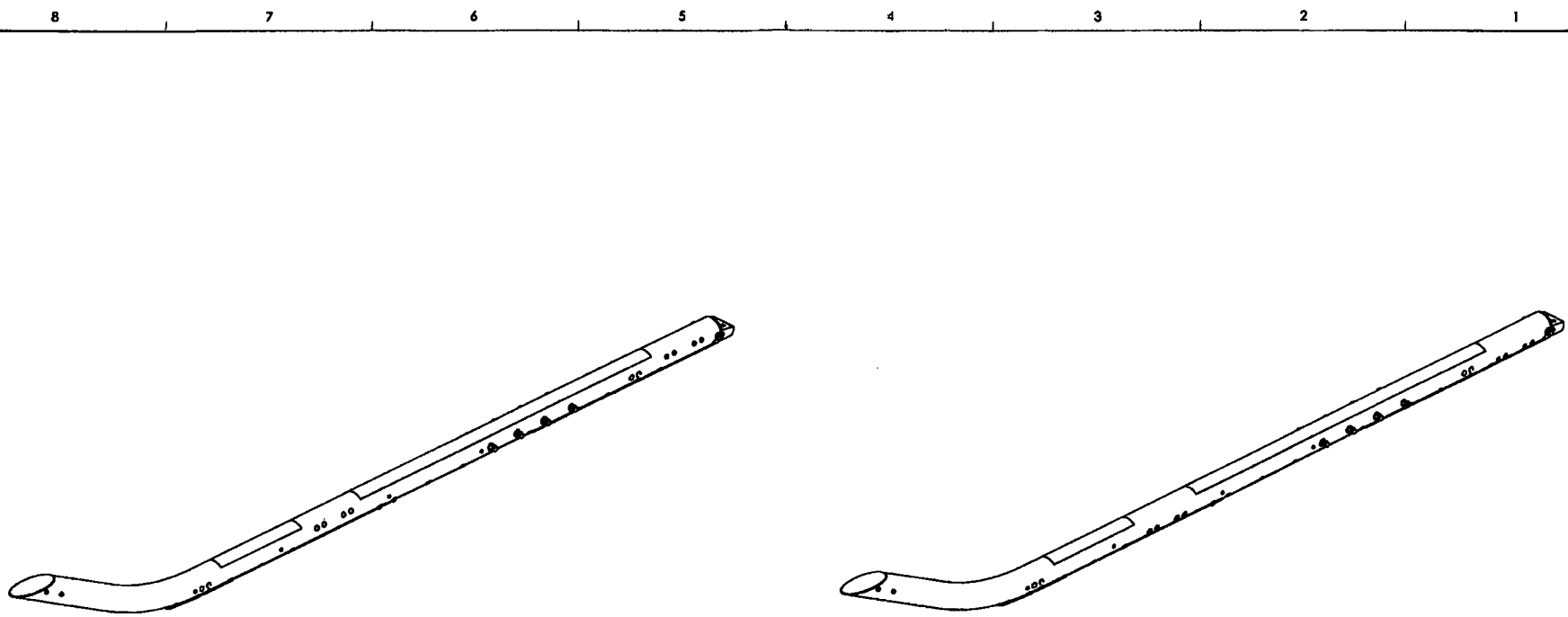
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MD

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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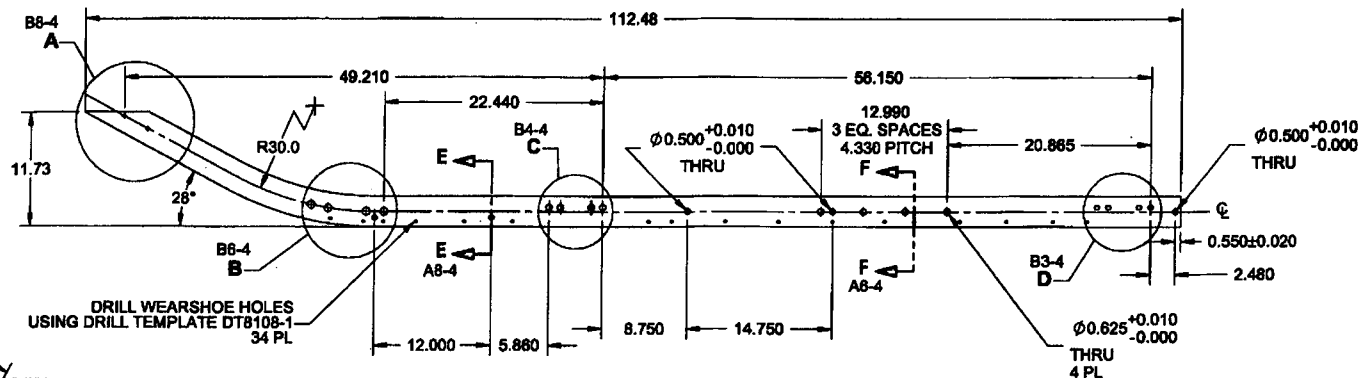


D2750-043 350 SKIDTUBE ASSEMBLY, LH

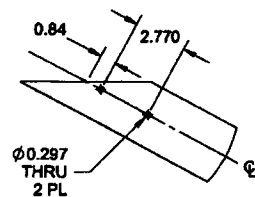
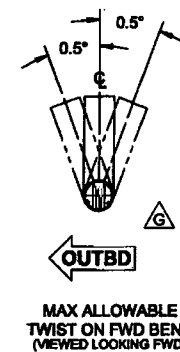
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
WAP

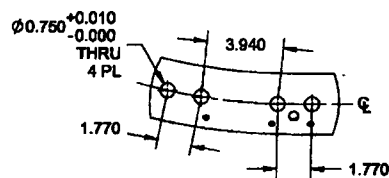
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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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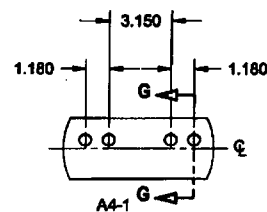
D2750-1 LH SKIDTUBE



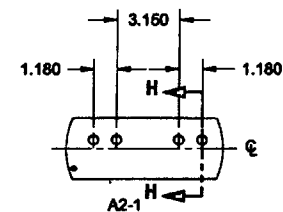
DETAIL A
SCALE 2X



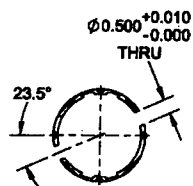
DETAIL B
SCALE 2X



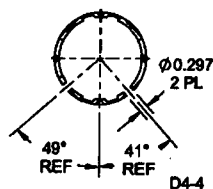
DETAIL C
SCALE 2X



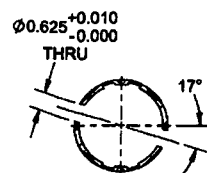
DETAIL D
SCALE 2X



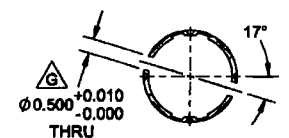
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



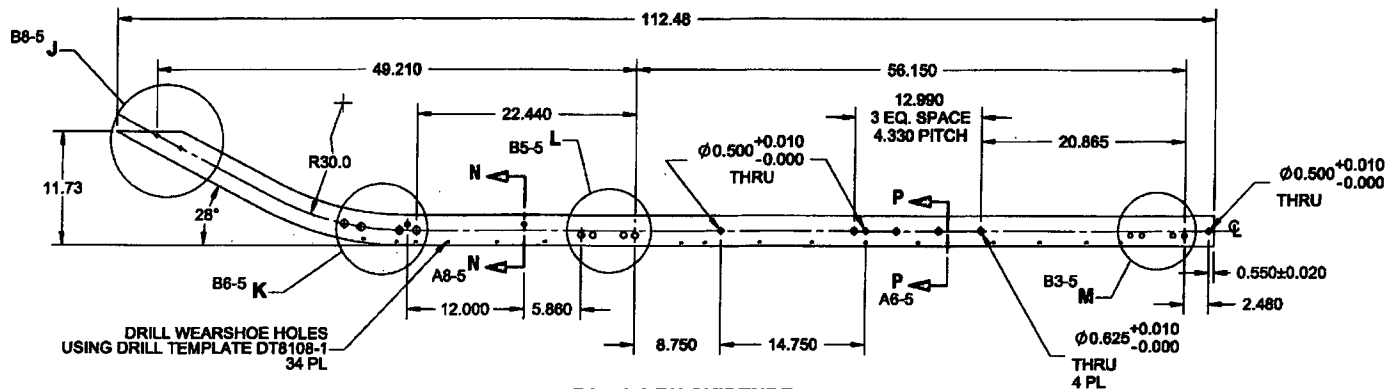
SECTION G-G
SCALE 3X, 4 PL



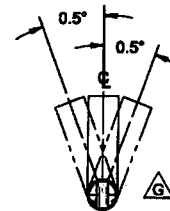
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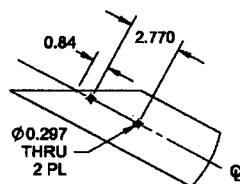
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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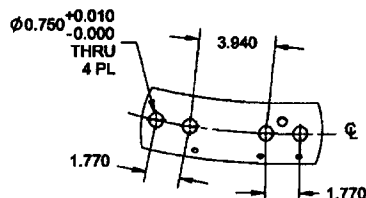
D2750-2 RH SKIDTUBE



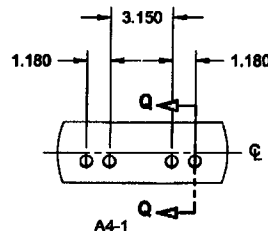
OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



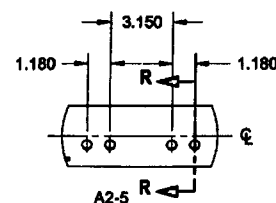
DETAIL J
SCALE 2X



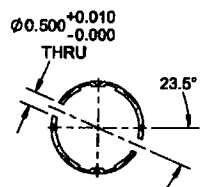
DETAIL K
SCALE 2X



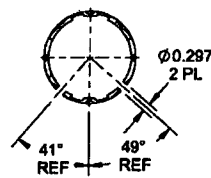
DETAIL L
SCALE 2X



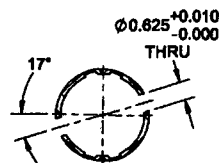
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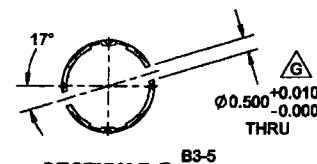
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

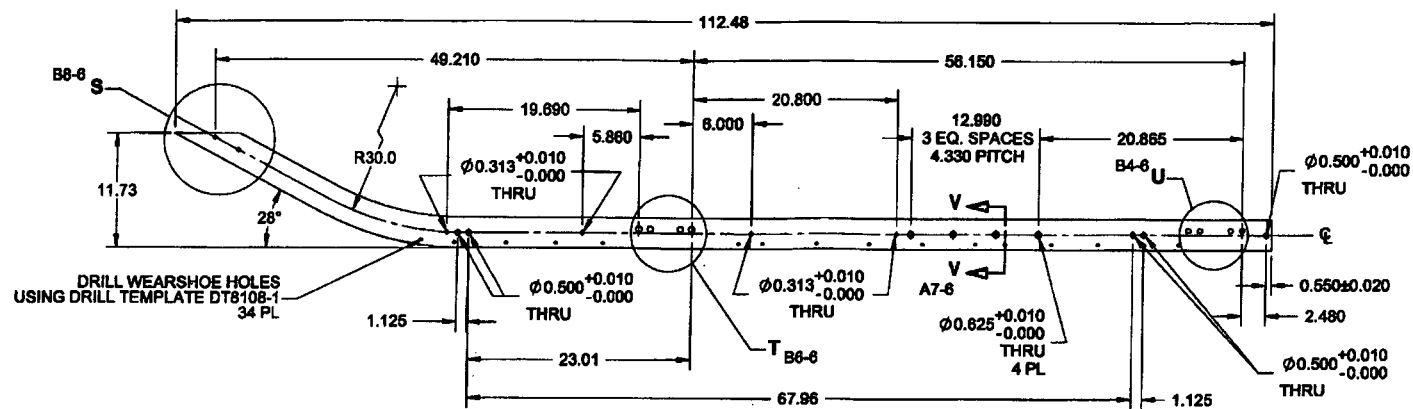


SECTION R-R
SCALE 3X, 4 PL

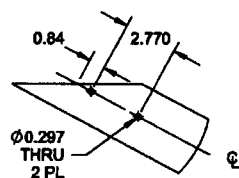
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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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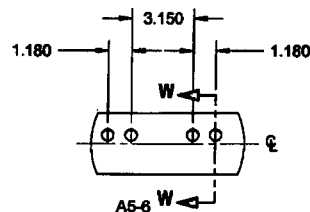
8 7 6 5 4 3 2 1



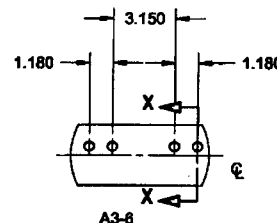
D2750-3 LH SKIDTUBE



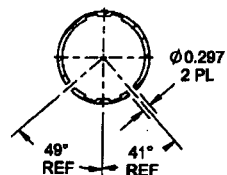
DETAIL S
SCALE 2X
D8-6



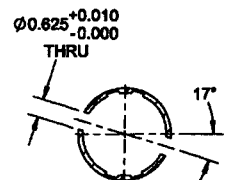
DETAIL T
SCALE 2X
C5-6



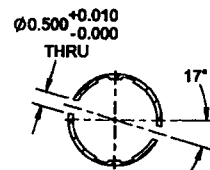
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B8-6

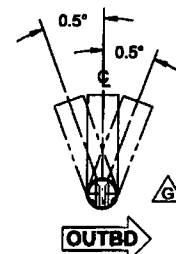
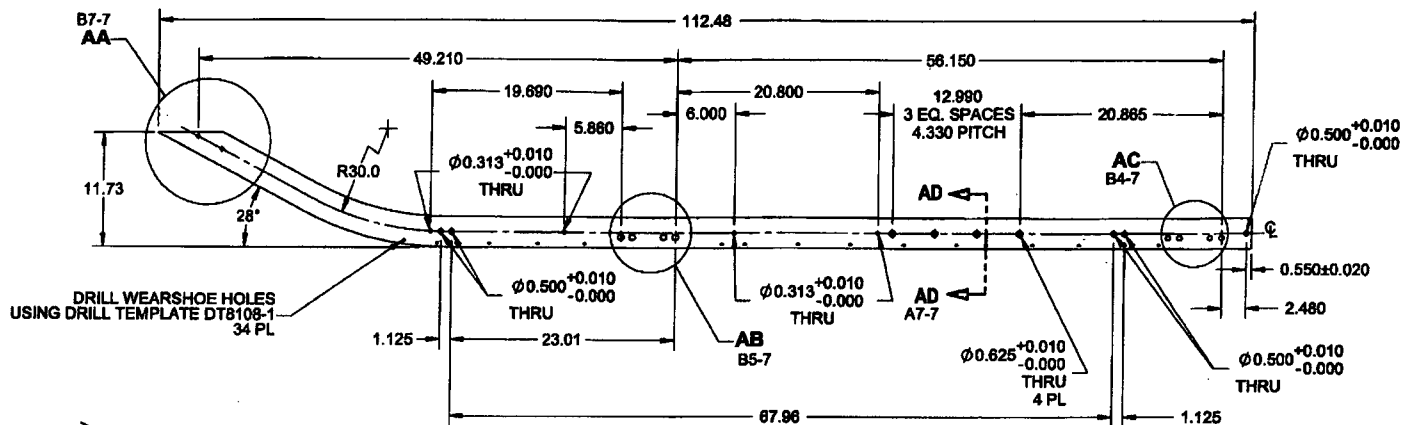


SECTION X-X
SCALE 3X, 4 PL
B4-6

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2013-08-13
JMP

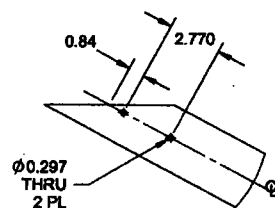
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

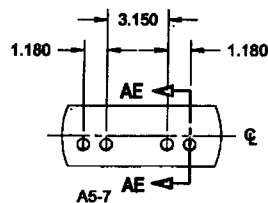


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

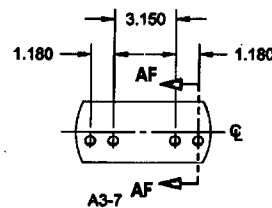
D2750-4 RH SKIDTUBE



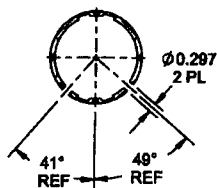
DETAIL AA
D7-7
SCALE 2X



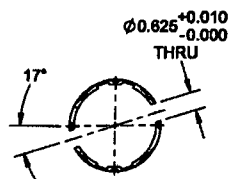
DETAIL AB
C4-7
SCALE 2X



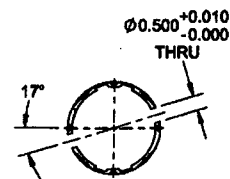
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



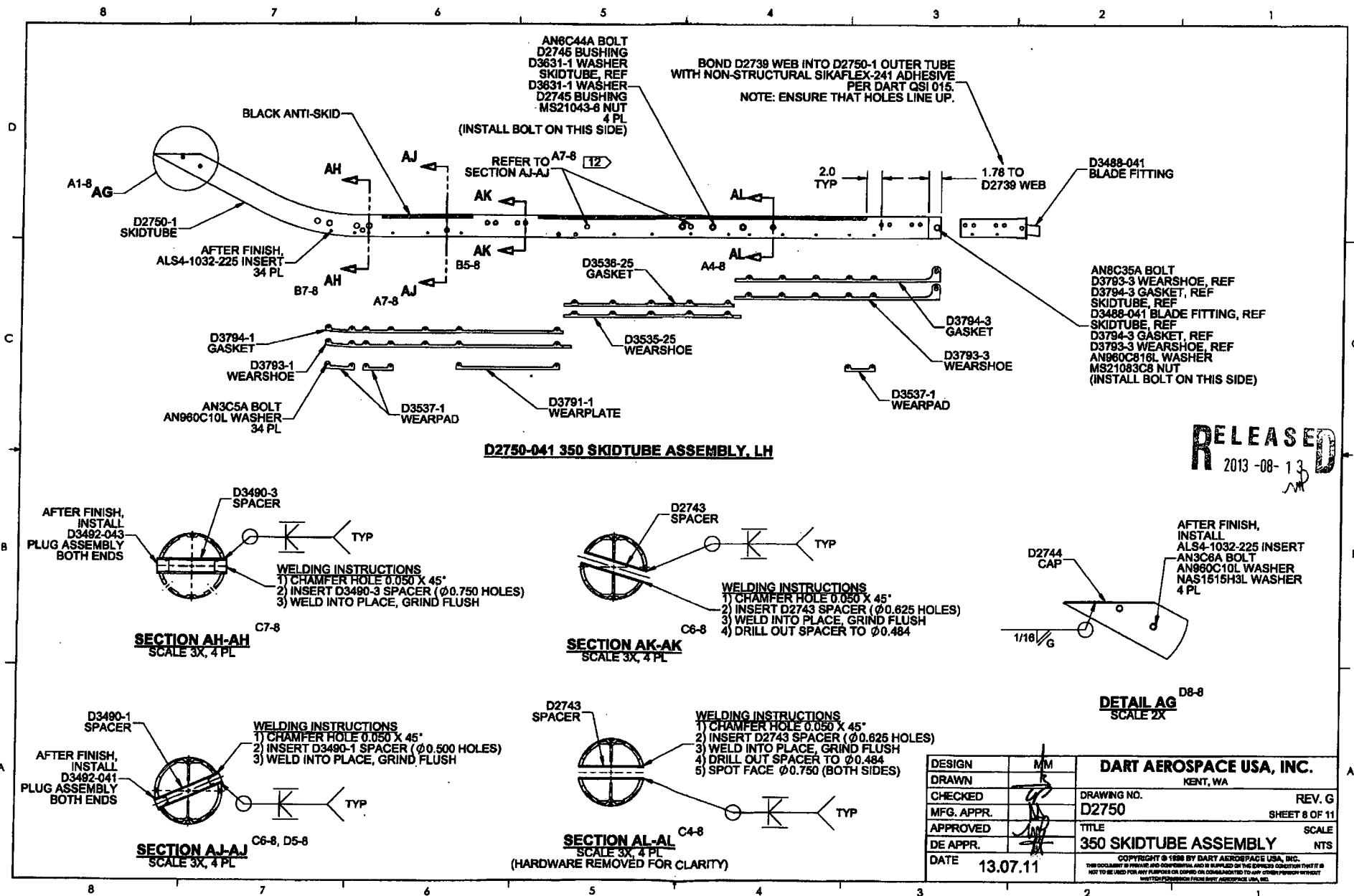
SECTION AE-AE
B6-7
SCALE 3X, 4 PL



SECTION AF-AF
B4-7
SCALE 3X, 4 PL

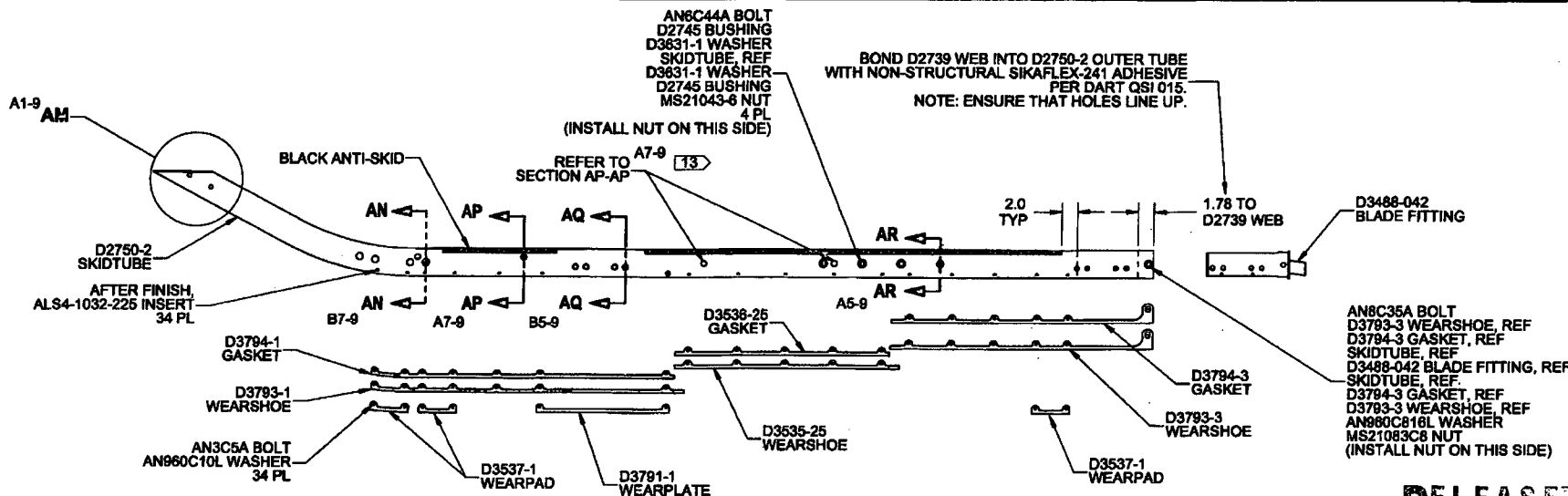
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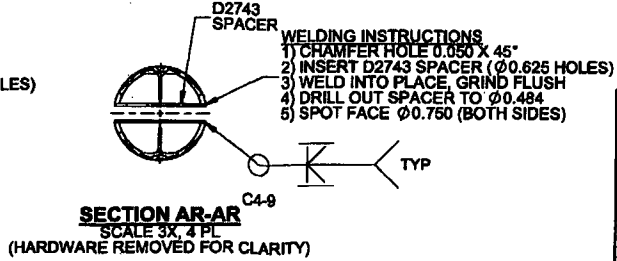
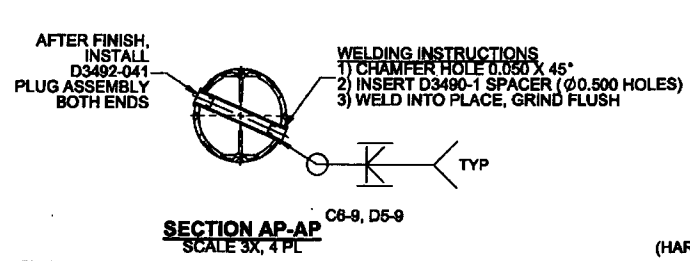
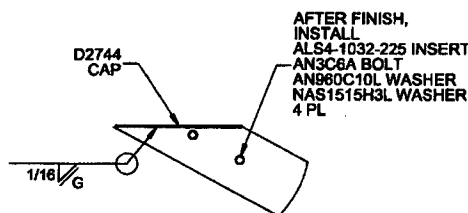
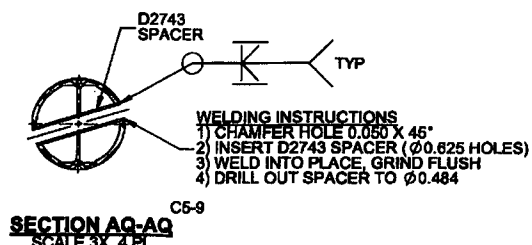
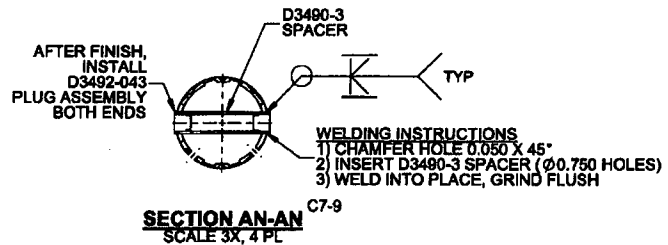
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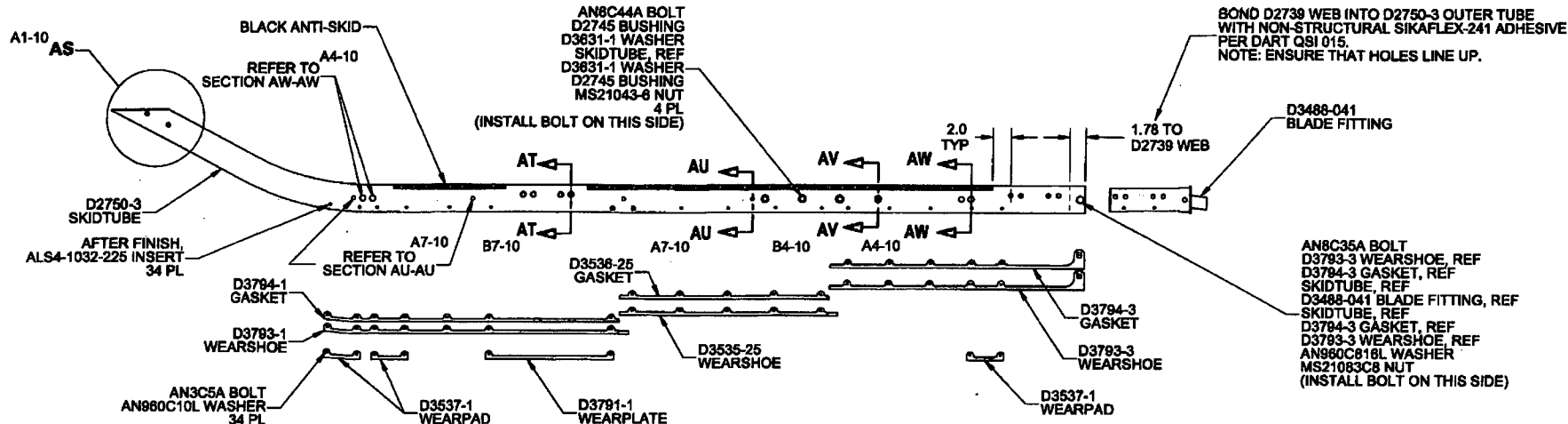
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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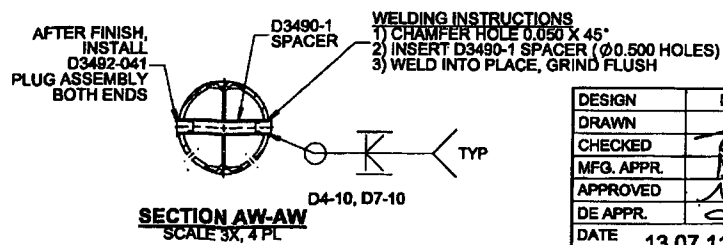
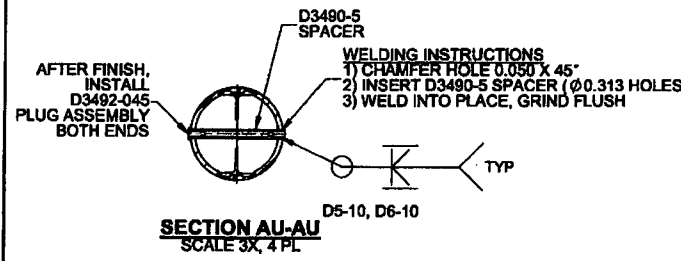
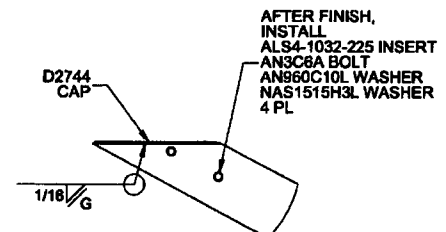
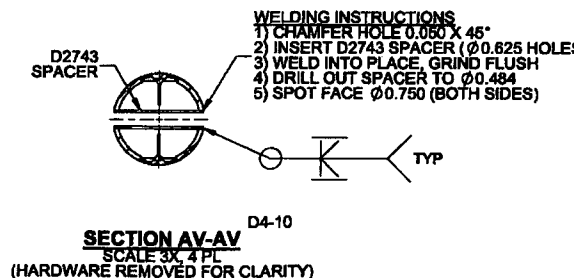
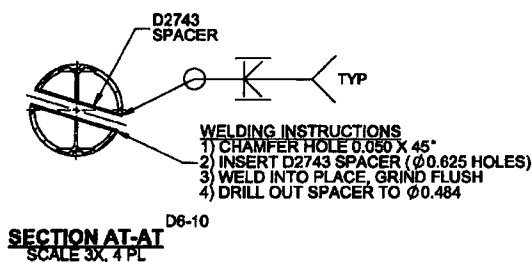
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8 7 6 5 4 3 2 1



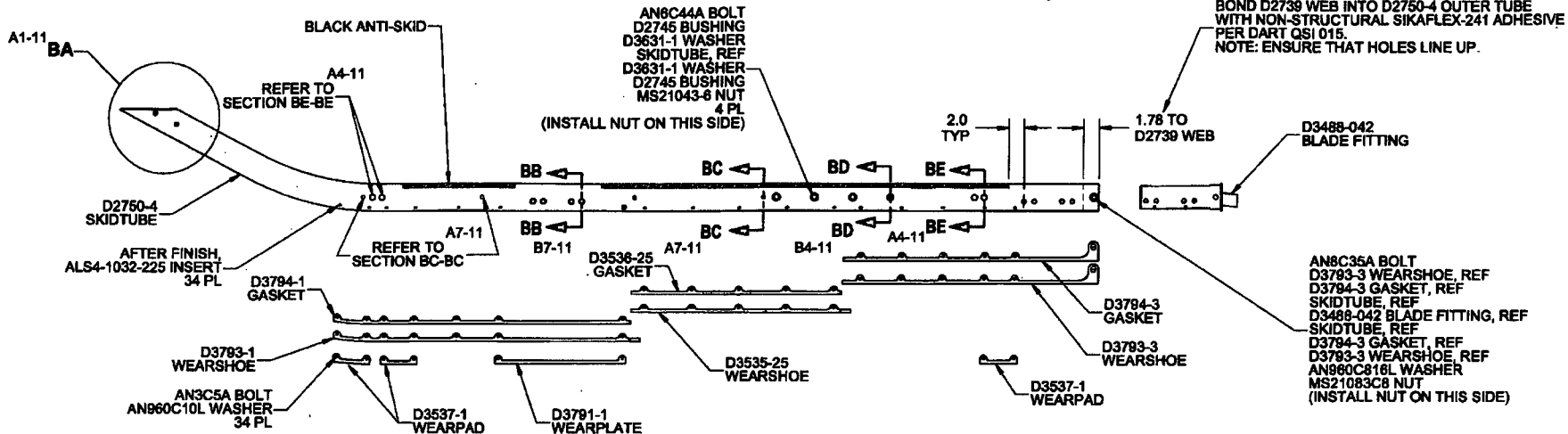
D2750-043 350 SKIDTUBE ASSEMBLY, LH

RELEASE
2013-08-13

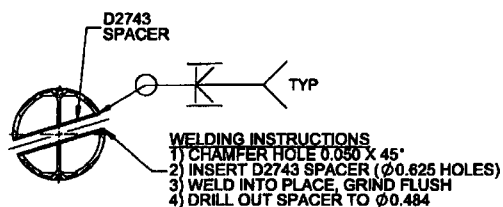


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8 7 6 5 4 3 2 1



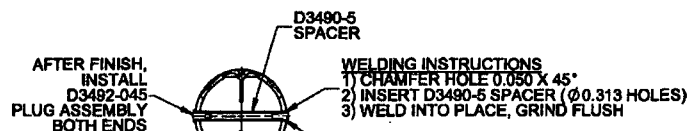
D2750-044 350 SKIDTUBE ASSEMBLY, RH



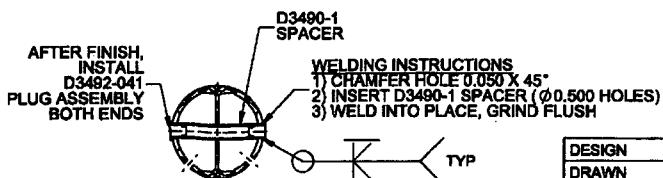
SECTION BB-BB
SCALE 3X, 4 PL



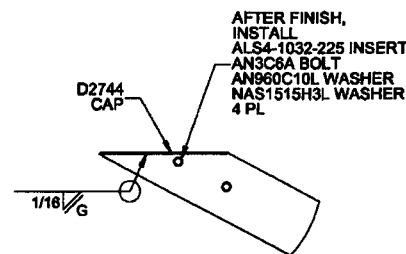
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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